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5293323

20-8337

94510-01

Job Sheet 211371



Part No: 94510-01

Job Qty: 1 pcs

Part Name: Cargo Basket Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/15/20

Job Tracking No:

Due Date: 8/3/20

Created By: Linda Lacelle

Type: SOLD

Description:

Note: 94510 REV.1 IPP REV:A 20.07.09 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	1 pcs	8/3/20		0.00	1.00	Small Fab - 1		
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
							Small Fab - 9		
							Small Fab - Various 1		
110	QC 5	1 pcs	8/3/20		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
							QC 5 - 82		
120	Packaging 3-1 - Stock - B4B	1 pcs	8/3/20		0.00	0.00	Packaging 3 - 1 - B4B		

DAS
24
9-89

20-08-06

20-08-11

DAS
69
9-89

AUG 1

P.T.O.

AUG 1 2020

Packaging 3 - 2 - B4B	
Packaging 3 - 3 - B4B	
Packaging 3 - 4 - B4B	
Packaging 3 - 5 - B4B	
Packaging 3 - 6 - B4B	
Packaging 3 - 7 - B4B	
Packaging 3 - 8 - B4B	
Packaging 3 - 9 - B4B	
Packaging 3 - 10 - B4B	
Packaging 3 - 11 - B4B	
Packaging 3 - 12 - B4B	
Packaging 3 - 13 - B4B	
Packaging 3 - 14 - B4B	
Packaging 3 - 15 - B4B	
Packaging 3 - 16 - B4B	
Packaging 3 - 17 - B4B	
Packaging 3 - 18 - B4B	
Packaging 3 - 19 - B4B	
Packaging 3 - 20 - B4B	
Packaging 3 - 21 - B4B	
Packaging 3 - 22 - B4B	
Packaging 3 - 23 - B4B	
Packaging 3 - 24 - B4B	
Packaging 3 - 25 - B4B	
Packaging 3 - 26 - B4B	
Packaging 3 - 27 - B4B	
Packaging 3 - 28 - B4B	
Packaging 3 - 29 - B4B	
Packaging 3 - 30 - B4B	
Packaging 3 - 31 - B4B	
Packaging 3 - 32 - B4B	
Packaging 3 - 33 - B4B	
Packaging 3 - 34 - B4B	
Packaging 3 - 35 - B4B	
Packaging 3 - 36 - B4B	
Packaging 3 - 37 - B4B	

130 QC 21 - FG

1 pcs

8/3/20

0.00 0.00

QC 21 - FG - 21

DAS
21
9-09

AUG 11 2020

QC 21 - FG - 70

QC 21 - FG - 9

QC 21 - FG - 77

Part Op 100 - 1-Transfer drill, deburr and rivet placard as per drawing detail G. 2-Drill hinges as per note 9. 3-Assemble basket as Descriptions: per drawing, see note 10.

110 - QC5- Inspect part completeness to step on W/O

120 - Identify as per dwg & Stock Location: _____

130 - QC21- Final Inspection - Work Order Release

DT 10676 DRILL Jig FOR Hinge

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
69812-01	Basket Lid Assembly	1 pcs (1 ea)	100-Small Fab - 1	S29096Z
84240-01	Lid Brace Installation	1 pcs (1 ea)	100-Small Fab - 1	S288599 ✓
84255-01	Handle Bar Installation	1 pcs (1 ea)	100-Small Fab - 1	S288636 ✓
84511-01	Basket Body Assembly	1 pcs (1 ea)	100-Small Fab - 1	S288636 ✓
CR3213-4-02	Cherry Rivet	2 Ea (2 ea)	100-Small Fab - 1	S239754 ✓
CR3213-5-02	Rivet (see item CR3213-5-2)	22 (22 ea)	100-Small Fab - 1	S21011 ✓
CR3523-5-02	Rivet	8 Ea (8 ea)	100-Small Fab - 1	S265314 ✓
D5764-1	Stud	4 pcs (4 ea)	100-Small Fab - 1	S265497 ✓
D5798-1	Bumper	3 pcs (3 ea)	100-Small Fab - 1	S257903
D5849-1	Placard	1 pcs (1 ea)	100-Small Fab - 1	S289531
MS20001P4-7200	Basket Hinge	1 Ea (1 ea)	100-Small Fab - 1	S262837 ✓
NAS1149F0663P	Washer (AN960-616)	8 Ea (8 ea)	100-Small Fab - 1	S247877 ✓

FG018 -
FG029 -
GA-TBD
CH003
ST-3/7
ST-190
Prelim -
SE-001
ST-262

CR3213-5-2 45001

x2 At QCS.

S29096Z
S288599 ✓
S288636 ✓
S288636 ✓
S239754 ✓
S21011 ✓
S265314 ✓
S265497 ✓
S257903
S289531
S262837 ✓
S247877 ✓

(016792)
O.R
UG 07 2021

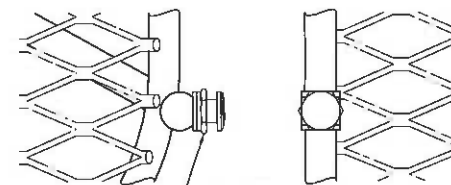
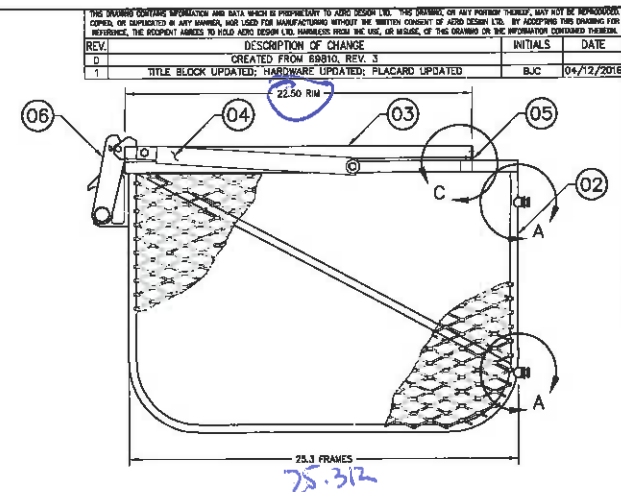
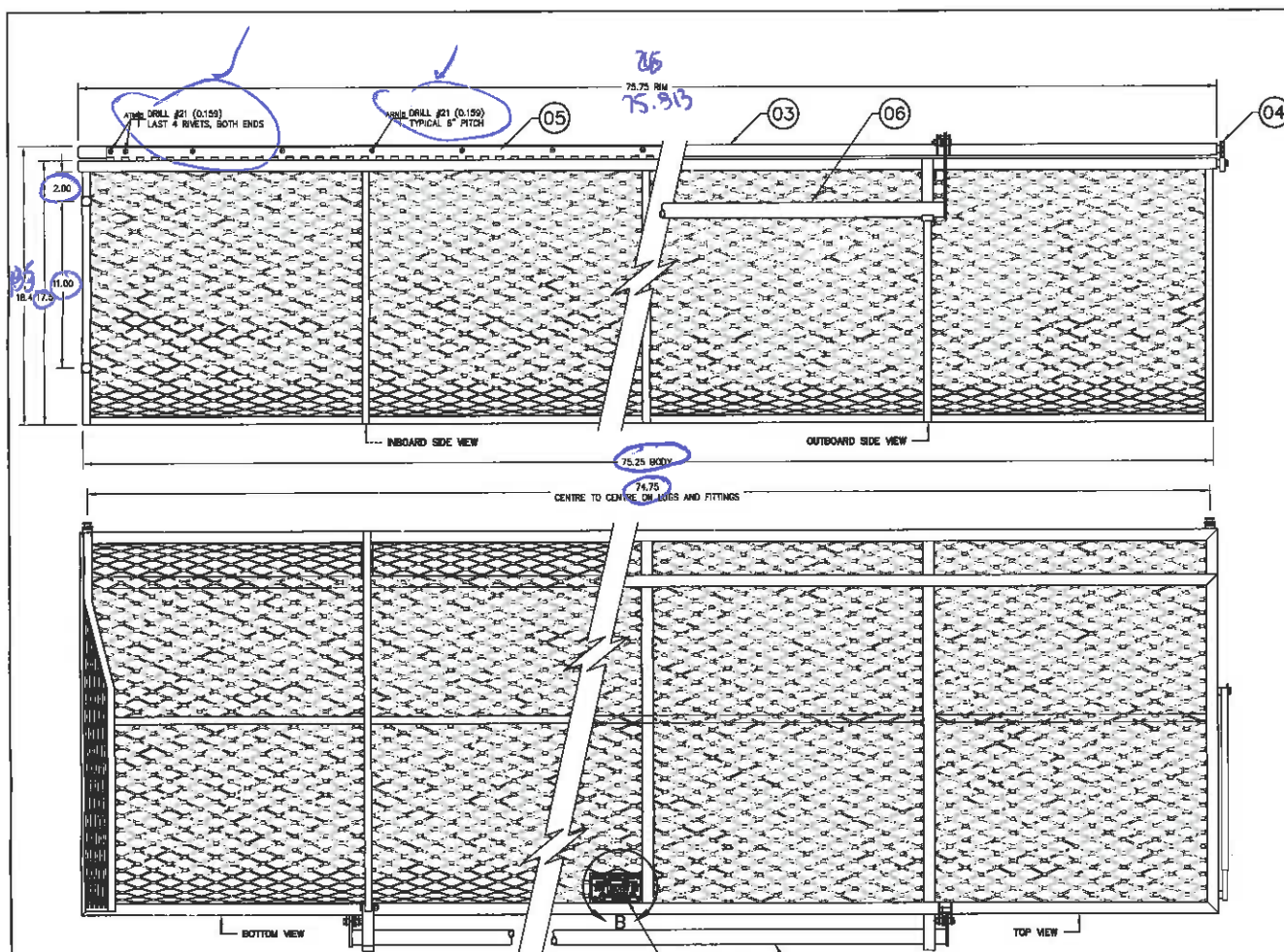
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	69812-01 - <i>ice</i>	1	0	0
	84240-01 <i>pick</i>	1	0	0
	84255-01 <i>pick</i>	1	0	0
	94511-01 <i>body</i>	1	3	0
	CR3213-4-02	2	582	0
	CR3213-5-02	22	0	0
	CR3523-5-02	8	200	0
	D5764-1	4	50	0
	D5798-1 <i>prehen</i>	3	0	0
	D5849-1	1	0	0
	MS20001P4-7200	1	14	0
	NAS1149F0663P	8	72	0

Part Specifications

Specifications could not be found.

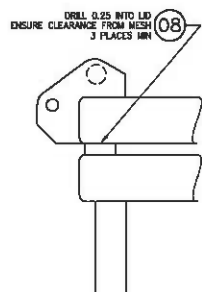
Plex 7/15/20 9:58 AM dart.lacelle.linda



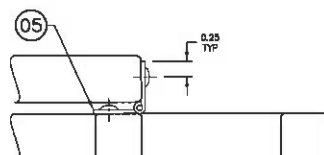
DETAIL A

SCALE 1 : 1
LOOKING AT LOWER ATTACHMENT, UPPER ATTACHMENT SIMILAR
TYPICAL FRONT AND REAR

NOTE:
1. ALL DIMENSIONS SHOWN ARE FOR REFERENCE ONLY. DIMENSIONS OF COMPONENTS
AND COMPLETE ASSEMBLY ARE DETERMINED IN PREVIOUS STEPS.

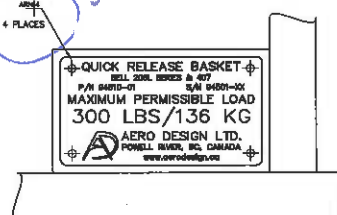


BUMPER INSTALLATION
SCALE 1 : 1



DETAIL E
SCALE 1 : 1
LOOKING AT HINGE

01 CARGO BASKET ASSEMBLY



DETAIL B
SCALE 1 : 1
LOOKING AT PLACARD BRACKET

A/R	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
4	CR3213-4-02	CHERRY RIVET	ALTY: ANCR4 400B8-14			
8	CR3523-5-02	CHERRY RIVET	ALTY: HR3523-5-02			
A/R	CR3213-5-02	CHERRY RIVET	ALTY: HR3213-5-02			
3	44209-14	BLUMICK	ARGUS INDUSTRIES			
1	94527-01	PLACARD				
1	84255-01	HANDLE BAR INSTALLATION				
1	MS20001P4	PIANO HINGE				72 INCHES LONG
1	84240-01	LID BRACE INSTALLATION				
1	60612-01	LID ASSEMBLY				
1	94511-01	BASKET BODY ASSEMBLY				
01	64510-01	CARGO BASKET ASSEMBLY				
QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE

BASIC CODE	DASH NO. FOR DIAMETER	APPROVALS	DATE
RD: HAS 323	N-MFD, HEAD NEAR SIDE	DRW: JEFF CLARKE	16 SEPT 2011
C-COUNTERSINK	D-DIMPLE	CHECKED	DATE
30%+1/2 OF SHEETS	TO BE IMPLIED	E. BURDON	25 OCT 2011
BASIC CODES:	DASH NO. FOR LENGTH	UNLESS OTHERWISE SPECIFIED	TOLERANCES ON:
BJ=MS20470AD	+C INSTALL NEW RIVET	DECIMALS	ANGLES
B8=MS20428AD	+R REMOVE/REPLACE RIVET	X100 ±0.010	±1/2"
ARM=CR3213	+X EXISTING RIVET	X30 ±0.05	
ATM=CR3523		X.X ±0.1	
AERO DESIGN LTD.			
8806A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G8 TEL: 250-463-5578 www.aerodesign.ca			
BELL 206L SERIES, 407 QUICK RELEASE CARGO BASKET CARGO BASKET ASSEMBLY			
SCALE 1 : 4	DRW. NO.	REV.	
SHEET 1 OF 1	A1	94510	1

Entered: JR Date: AUG 24 2020NCR No. 20-8357

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

Job: <u>211371</u> Part No. <u>94570-01</u>	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☒ Water Jet ☐ Supplier ☐ Quality ☐														
Date: <u>20/7/15</u>	Sequence #: <u>100</u>	QTY Affected: <u>①</u>		MRB (QSI042) <u>INSP 12</u> <u>9/20/2/15</u>												
Description Work Order Deviation <u>Substitute:</u> <table style="width:100%; border-collapse: collapse;"> <thead> <tr> <th style="text-align: left;">Aero P/N</th> <th style="text-align: left;">Dart P/N</th> <th style="text-align: left;">DESCRIPTION</th> </tr> </thead> <tbody> <tr> <td>94527-01</td> <td>D5849-1</td> <td>PLACARD</td> </tr> <tr> <td>49205-14</td> <td>D5798-1</td> <td>BUMPER</td> </tr> <tr> <td>96710-01</td> <td>D5764-1</td> <td>FITTING / STD</td> </tr> </tbody> </table>		Aero P/N	Dart P/N	DESCRIPTION	94527-01	D5849-1	PLACARD	49205-14	D5798-1	BUMPER	96710-01	D5764-1	FITTING / STD	Disposition <u>Acceptable. The Dart parts parts are functionally identical to the Aero design parts they replace.</u>		Completed By <u>9/20/2/15</u> Lead hand / Supervisor DAS 9 9-88 <u>20-8-21</u> QC / QA Coordinator DAS 9 9-88 <u>20-8-21</u>
Aero P/N	Dart P/N	DESCRIPTION														
94527-01	D5849-1	PLACARD														
49205-14	D5798-1	BUMPER														
96710-01	D5764-1	FITTING / STD														
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☒ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☒ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread														
Other/Details:																